

Work Order ID 143367

Wednesday, April 13, 2016 3:18:49 PM

143367

Page 1

Item ID: D4324-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Armrest Assembly

Stop ***NS2***

Start Date: 4/28/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 5/4/2016 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: UMF Date: 16-4-13

Tooling:

Date:

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4324	B

110

0.00

110

Small Fab

Memo

0.01

Small Fab

ASSEMBLE PART SHOWN AS PER DWG

5 FF APR 14 2016

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

(5) DAS 38 9-89 APR 14 2016

130

Pick Kit

0.00

130

Packaging

Memo

0.00

Packaging

PICK AND BAG HARDWARE AS PER DWG AND NOTE 9.

DAS 38 9-89 APR 14 2016

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

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Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

140

QC4- 100% Inspect kits for completeness

0.00

140

QC

Memo

0.00

Quality Control

DAS
28
9-89
APR 14 2016

150

Identify as per dwg & Stock Location **ST459** 0.00***150***

Packaging

Memo

0.00

Packaging

DAS
6
9-89
APR 14 2016

160

QC21- Final Inspection - Work Order Release 0.00

160

QC

Memo

0.00

Quality Control

MCS
APR 14 2016MCS
APR 14 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER: ☐					

Picklist Print

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Page 1

Work Order ID: 143367

143367

Parent Item: D4324-011

D4324-011

Parent Item Name: Armrest Assembly

Start Date: 4/28/2016

Required Date: 5/4/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 14.04.24 NEW ISSUE DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3-4A		Purchased	No			110	Each	343.0000	1	2		DAS 6 9-89	
AN3-4A									**				

Bolt

Location	Loc Qty	Loc Code
over003	300	
m134502	300	
ST350	43	
m133990	43	

D4324-041

Manufactured No

110

Each

11.0000

1

25

DAS
6
9-89

D4324-041

Armrest Weldment

Location	Loc Qty	Loc Code
ST092	2	
141300	2	
ST103a	9	
143363	9	

D4324-043

Manufactured No

110

Each

5.0000

1

25

DAS
6
9-89

D4324-043

Arm Support Assembly

Location	Loc Qty	Loc Code
ST092	5	
143521	5	

APR 14 2016

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**WORK ORDER NON-CONFORMANCE / UPDATE**

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
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Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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Work Order ID: 143367

143367

Parent Item: D4324-011

D4324-011

Parent Item Name: Armrest Assembly

Start Date: 4/28/2016

Required Date: 5/4/2016

Start Qty: 2.00

Required Qty: 2.00

D4324-045	Manufactured	No	110	Each	10.0000	1	25	DAS 6 9-89
D4324-045								
Cushion Assembly								

			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			ST455	10				
			119006	10			5	
AN3-4A	Purchased	No		130	Each	343.0000	2	4/10
AN3-4A								
Bolt								

			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			over003	300				DAS 6 9-89
			m134502	300				
			ST350	43				
			m133990	43			10	
AN3-12A	Purchased	No		130	Each	122.0000	1	25
AN3-12A								
Bolt								

			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			over003	100				
			m134257	100				
			ST349	22				
			m133064	16				
			m133234	6			5	
MS21075L3	MS21075L3N	Purchased		130	Each	148.0000	3	6/15
MS21075L3								
Nut Plate								

			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			GA	148				DAS 6 9-89
			m134257	148				

APR 14 2016

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:12.5%;">Skid-tube ☐</td> <td style="width:12.5%;">Cross tube ☐</td> <td style="width:12.5%;">Water Jet ☐</td> <td style="width:12.5%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐											
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Work Order ID: 143367

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Parent Item: D4324-011

D4324-011

Parent Item Name: Armrest Assembly

Start Date: 4/28/2016

Required Date: 5/4/2016

Start Qty: 2.00

Required Qty: 2.00

MS51861-45C

Purchased

No

110

Each

34.0000

4

8 20

MS51861-45C

Screw

FF **DAS**
8
9-89
APR 14 2016

Location

Loc Qty

Loc Code

GA

34

m128993

24

m134501

10

20

NAS1149F0332P

Purchased

No

130

Each

1,930.000

3

6 15

NAS1149F0332P

Washer

DAS
8
9-89

Location

Loc Qty

Loc Code

GA

312

m133709

312

ST262

1618

m134134

118

m134257

1500

15

NAS1149F0363P

Purchased

No

130

Each

394.0000

1

2 5

NAS1149F0363P

WASHER

DAS
8
9-89

Location

Loc Qty

Loc Code

ST262

394

124555

394

5

DAS
8
9-89
APR 14 2016

DAS
28
9-89

DQA: _____ Date: _____

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